



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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DSK076
Job Sheet 204758



Part No: DSK076

Job Qty: 8 pcs

Part Name: D2891-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/18/19

Job Tracking No:

Due Date: 2/3/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	8 pcs	2/3/20	2/3/20	0.06	5.37	Doosan - 1		JRN 20/01/20
110	QC 2	8 pcs	2/3/20	2/3/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		JRN 10/01/20



Container No: S244560



Part: DSK076

Job No: 204758

Serial No/Batch: S244560

Revision:

Inspector:

Exp Date:

Instructions:

Date: 01/03/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

120	QC 8	8 pcs	2/3/20	0.00	0.00	QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	11 26-01-06
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
130	Packaging 3-1 - Stock - B4B	8 pcs	2/3/20	0.00	0.00	Packaging 3 - 1 - B4B	9mmL 20/01/07
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	

•12/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS
140	QC 21 - SA	8 pcs	2/3/20	0.00 0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9.20
					QC 21 - SA - 53	
Part Op 100 - Turn blank for as per Folio FA046 DT8671						
Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)						
120 - QC8 Machining-4 (QC8- Inspect parts - second check)						
130 - Packaging3-2 (Identify as per dwg & Stock Location: LOCATION: MAT060						
140 - QC21 (QC21- Final Inspection - Work Order Release)						
JAN 07 2020						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D6104-003	Round Billet, 17-4	8 pcs (1 ea)	100-Doosan - 1	5	1x5240283	
				1x5204931	3x5141245	
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Doosan - 1	D6104-003	8	18	0		
Part Specifications						
Specifications could not be found.						

Plex 12/18/19 1:53 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	204758
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.276	2.276	2.277	2.277	2.2787
B	3.702	3.722		3.710	3.711	3.712	3.710	3.712
C	2.564	2.584		2.579	2.574	2.574	2.573	2.572
D	0.718	0.738		0.729	0.730	0.730	.730	.730
E	0.090	0.110		0.102	.102	.100	.102	.100
F	2.464	2.484		2.473	2.474	2.475	2.472	2.472
G	2.029	2.049		2.037	2.036	2.035	2.036	2.036
H	2.964	2.984		2.974	2.976	2.975	2.975	2.974
I	0.913	0.933		0.932	0.930	.930	.930	.930
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		0.103	.103	.103	.103	.103
L								
M								
N								
O								
P								

Measured by:	JD	Date:	2010/03
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Audited by:	JL	Date:	20-01-06
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Prototype Approval:		Date:	
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Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

Entered: _____ Date: _____

DA
AEI

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐					
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042) ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
								Completed By			
								Lead hand / Supervisor			
								QC / QA Coordinator			

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D	0.718	0.738		.730	.730	.730		
E	0.090	0.110		.102	.102	.102		
F	2.464	2.484		2.473	2.471	2.471		
G	2.029	2.049		2.040	2.038	2.038		
H	2.964	2.984		2.975	2.974	2.974		
I	0.913	0.933		.930	.930	.930		
J	0.022	0.042		.032	.032	.032		
K	0.090	0.110		.108	.102-.098	.108		
L								
M								
N								
O								
P								

Measured by:	JSD	Date:	20-01-07
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Audited by:	SL	Date:	20-01-06
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Prototype Approval:		Date:	
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Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	